

Work Order ID 53500

November 6, 2009 11:19:05 AM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rib / Gusset Assembly

Start Date: 06/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date:

09-11-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: <i>M109213</i>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*09 11 12**PD 09.11.12 (6)**PD 09.11.12 6*

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Page 2

Item ID: D3826-041

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Start Date: 06/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

B/C

09 11 12

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/13

mf

09-11-13

Picklist Print

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Page 1

Work Order ID: 53500

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly

Comments:

Start Date: 06/11/2009

Required Date: 13/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2235-1RevB1 Manufactured No



Basket Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 10

53215 10

Main Warehouse

WA 6

50565 3

51871 3

6.0000



Eplog 11.12

6 ✓

D3929-041RevA Manufactured No



Gusset Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3

47273 1

52831 2

3.0000



Eplog 11.12

*1
2 ✓*

B53499 → 3

Picklist Print

November 6, 2009 11:19:10 AM

Work Order ID: 53500



Parent Item: D3826-041RevB



Parent Item Name: Rib / Gusset Assembly

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3929-042RevA		Manufactured	No				Each	10.0000	6.0000			
Gusset Assembly												

Pl 09.11.12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

50567

2

50869

1

Main Warehouse

WA

7

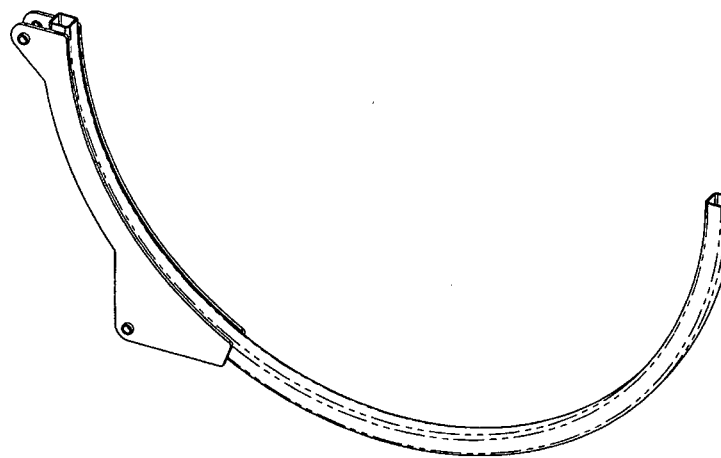
53343

7

(6) ✓

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△ B



D3826-041 RIB/GUSSET ASSY

SHIP TO
RECEIVED
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER

NO. 53500

PC 09-11-C

RELEASED
9/12/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

△ B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

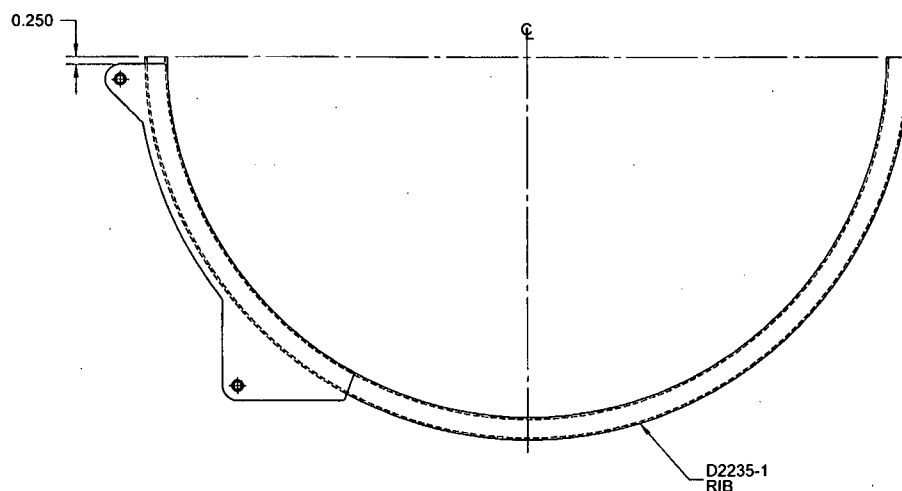
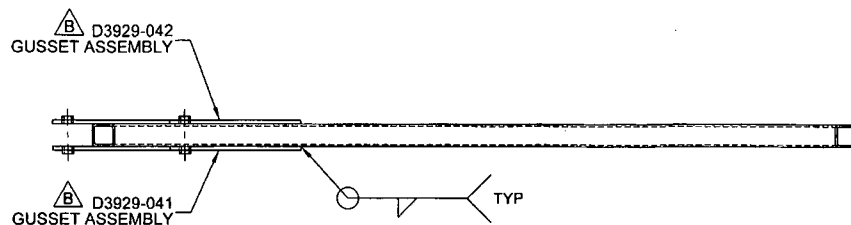
DRAWING NO. D3826
REV. B
SHEET 1 OF 2
TITLE RIB/GUSSET ASSY
SCALE NTS

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8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53500

RELEASED
9/10/12-14

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3826	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB/GUSSET ASSY	NTS
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8 7 6 5 4 3 2 1